

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Work Order ID 153547

Monday, November 21, 2016 10:31:53 AM

153547

Page 2

Item ID: D5393-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Weldment
Start Date: 11/21/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/21/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Small Fab	Memo Assemble nut and clevis as per dwg (HAND TIGHTEN NUT) use anti-seize on thread. A/R ANTI-SEIZE BATCH: _____	0.00 0.04							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							

N/A 16-11-21
(Signature)

USED FOR BASKET
FLIGHT TEST.

DQA: _____ Date: _____



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Work Order ID 153547

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153547

Page 3

Item ID: D5393-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
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Start Date: 11/21/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/21/2016 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21 - Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.02							
Quality Control									

RD16-701-02

16/11/23

16-11-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER :																					

Picklist Print

Page 1

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Work Order ID: 153547

153547

Parent Item: D5393-043

D5393-043

Parent Item Name: Strut Weldment

Start Date: 11/21/2016

Required Date: 11/21/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.02.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4794-3 *D4794-3* Stud		Manufactured	No				Each	9.0000		2			
									**			EL 11/11/21	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA001			9					
					145967			9				2	
D5393-1 *D5393-1* Strut		Manufactured	No				Each	1.0000		1			
									**			EL 11/11/21	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST356			1					
					152700			1					
AN665-34R *AN665-34R* Clevis		Purchased	No				Each	13.0000		2			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST330			13					
					M135948			13					
NAS509-4C *NAS509-4C* NUT		Purchased	No				Each	1.0000		2			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST551			1					
					M134676			1					

DQA: _____ Date: _____

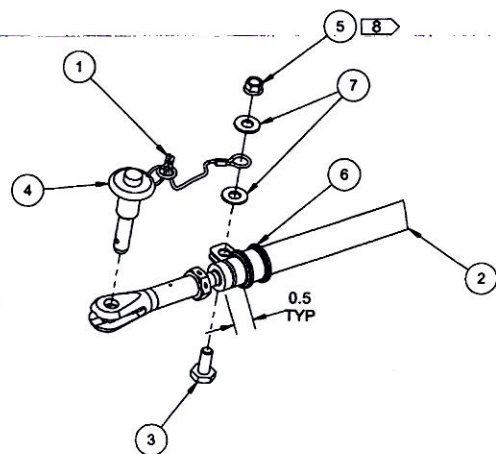


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**DETAIL A
(TYP)**

D5393-041 STRUT ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
	X	D5393-041	STRUT ASSEMBLY
1	2	D2690-6	LANYARD ASSEMBLY
2	1	D5393-043	STRUT WELDMENT
3	2	AN3C3A	BOLT
4	2	MS17984-C405	PIN, QUICK RELEASE
5	2	MS21043-3	NUT, SELF-LOCKING
6	2	MS21919WCF8	CLAMP
7	4	NAS1149C0332R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153547

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.76 lbs
- 8) TORQUE NUTS TO 20-25 in-lb

RELEASED
2016-02-08
ECN 10-520

APPROVED

A		NEW ISSUE		RF	16.01.27
REV.	DESCRIPTION			BY	DATE
DESIGN	RF			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF				
CHECKED	VS			DRAWING NO.	REV. A
MFG. APPR.	DD			D5393	SHEET 1 OF 3
APPROVED	HS			TITLE	SCALE
DE APPR.	DS			STRUT ASSEMBLY	NTS
DATE	16.01.27			COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



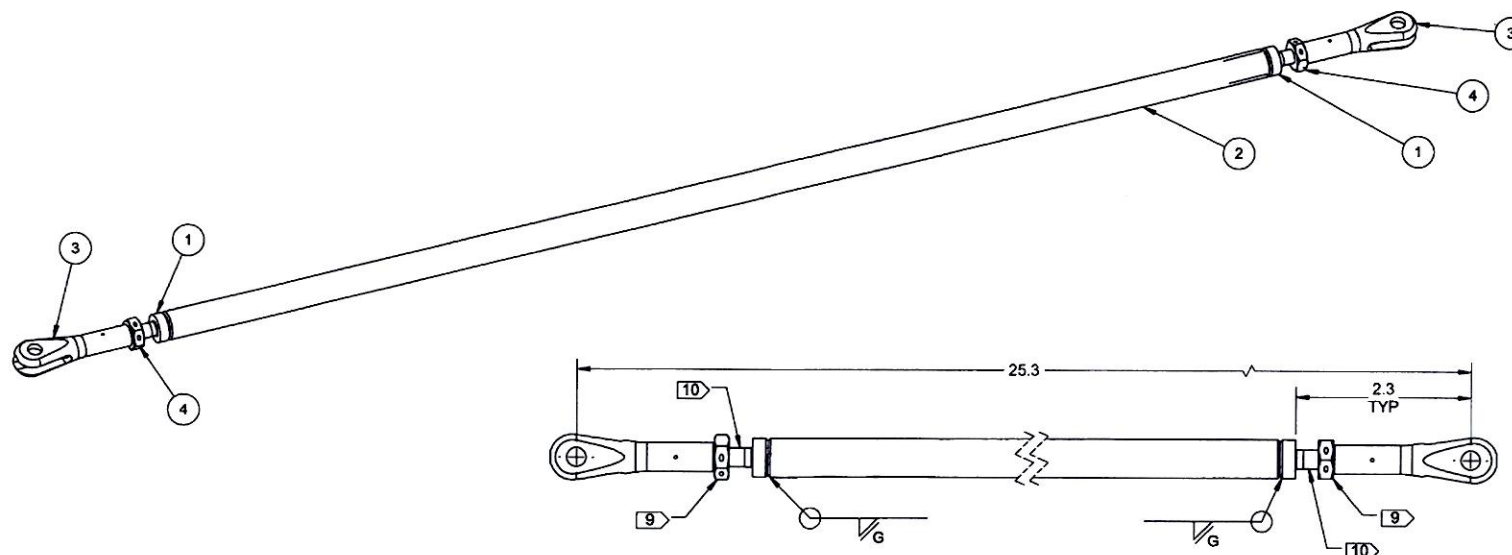
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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ITEM	QTY -043	P/N	DESCRIPTION
	X	D5393-043	STRUT WELDMENT
1	2	D4794-3	STUD
2	1	D5393-1	STRUT
3	2	AN665-34R	THREADED CLEVIS
4	2	NAS509-4C	NUT, JAM



D5393-043 STRUT WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.62 lbs
- 8) WELD PER DART QSI 004
- 9) HAND TIGHTEN NAS509-4C NUT
- 10) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

RELEASED
2016-02-08

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5393	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	16.01.27	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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WORK ORDER NON-CONFORMANCE / UPDATE

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0.030 x 45°
CMF, 2 PL

Ø

20.40

19.90

Ø0.500
REF

0.049
REF

D5393-1 STRUT

Acceptable for Engineering for Test Fit

[Signature]

2016.11.23

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF. DART SPEC M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs

RELEASED
2016-02-08

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
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APPROVED	HS	TITLE	SCALE
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
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			Lead hand / Supervisor Approval Verification		
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